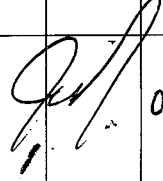
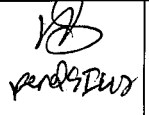
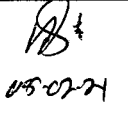


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DART AEROSPACE LTD		Work Order:	21385
Description: Bracket Assembly		Part Number:	D3183-041
BC 04.02.1978			D3183-042
Dwg: D3183 Rev. A page 1, 2, 4		Qty:	4 Kits
RF 03.10.02			Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	04.08.23	4
2	MV	Cut (1) blank per D3183-041 & (1) blank per D3183-042 Cut blanks (2.00" x 1.50") x 4.30" Long Bar Material: 17-4 SS per AMS 5604/5643 (M17-4-B2.000x01.500) Batch: 214579	me	04.08.23	4
3	MV	Machine D3183-1 as per Folio FA320 and Dwg D3183	EE	04.11.24	4
4	QC2	Inspect parts as they come off the CNC machine	EE	04.11.24	4
5	MV	Machine D3183-2 as per Folio FA320 and Dwg D3183	N/A	W	
6	QC2	Inspect parts as they come off the CNC machine	N/A	W	
7	MV	Deburr Break all sharp edges 0.005 to 0.015	EE	04.11.24	4
8	MV	Scribe batch number to D3183-1 & D3183-2 as per Dwg D3183	J	05-01-20	4
9	QC5	Second check D3183-1 and D3183-2	EE	05/01/24	4
10	GA	Assemble D3183-041 as per Dwg D3183 Pick: 2 D3183-045 bearing Qty Part Number Description Batch 2 D3121-17 Washer B20781 4 D3183-5 Bearing 2 D3183-7 Washer 2 MS24694-S50 Screw 2 D3121-21 screw B21881A	EP	04/12/02	
11	GA	Assemble D3183-042 as per Dwg D3183 Pick: Qty Part Number Description Batch 2 D3121-17 Washer 4 D3183-5 Bearing 2 D3183-7 Washer 2 MS24694-S50 Screw	N/A	W	
12	QC5	Inspect work to Step 10 & 11	EE	05.01.20	4
13	ST	Identify and Stock in Spacedoor cell D3183-041 Qty 4 D3183-042 Qty 0	EE	05.01.22	4
14	AC	Parts to Stock and Prorate Cost to parts per Step 13 Cost / part 126.42	545	05.01.27	4
15	DC	Close W/O 170.93 Inspect Level 21	KJ	05.02.21	4

Rev	Date	Change	Revised By	Approved
A	03.03.28	New issue	KJ/RF	RF

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector
01-12-06	10	Permanent Change		05-01-08	N/A		

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

DART AEROSPACE LTD		Work Order:	21385
Description: Washer		Part Number:	D3183-7
Inspection Dwg: D3183 Rev: C			D3183-1
			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.052	+/-0.005					
0.600 0.400	+/-0.010	0.401	✓			
0.394	+0.005/-0.000					
0.182	±0.01	0.184	✓			
0.070	"	0.069	✓			
0.100	"	0.101	✓			
R.063	"	R.063	✓			
R.189	"	R.188	✓			
3.881	"	3.884	✓			
4.17	±0.03	4.164	✓			
0.830	±0.01	0.835	✓			
0.500	"	0.501	✓			
0.218	"	0.216	✓			
1.030	"	1.035	✓			
1.90	±0.03	1.891	✓			
1.012	±0.01	1.008	✓			
0.786	"	0.787	✓			
R.19		R.188	✓			
φ.392	±0.002 -0.000	φ.3927	✓			
0.162	±0.01	0.160	✓			
2.799	"	2.804	✓			
2.075	"	2.080	✓			
0.162	"	0.162	✓			
0.032	"	0.026	✓			
0.281		0.284	✓			
0.200		0.201	✓			

Measured by: <i>EC</i>	Audited by: <i>JK</i>	Prototype Approval:	N/A
Date: 04.11.23	Date: 04.11.23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3183-041/-042)	KJ/RF	<i>KE</i>

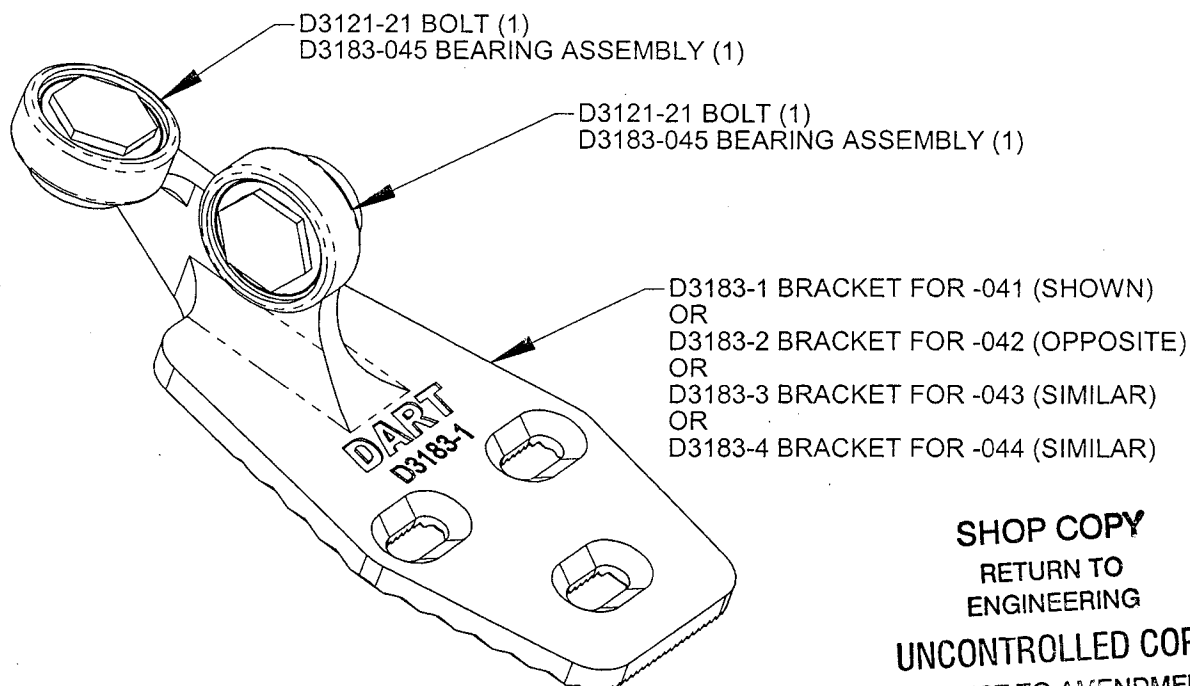
RELEASED

04.04.20



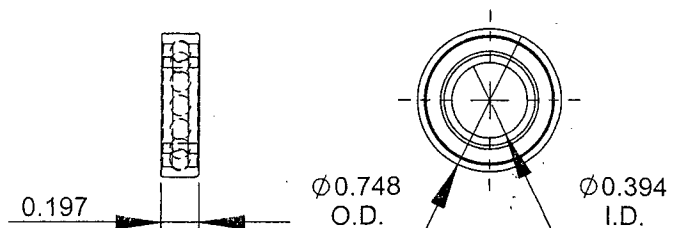
DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	

RELEASED
04.03.01



D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)

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NO. 21385

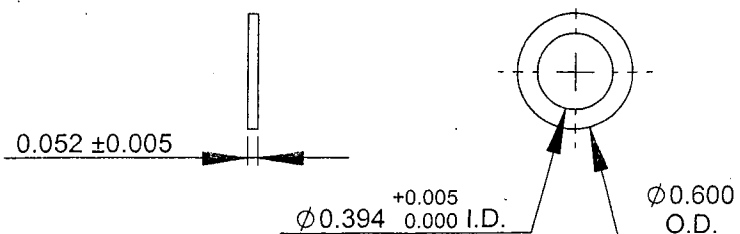


D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



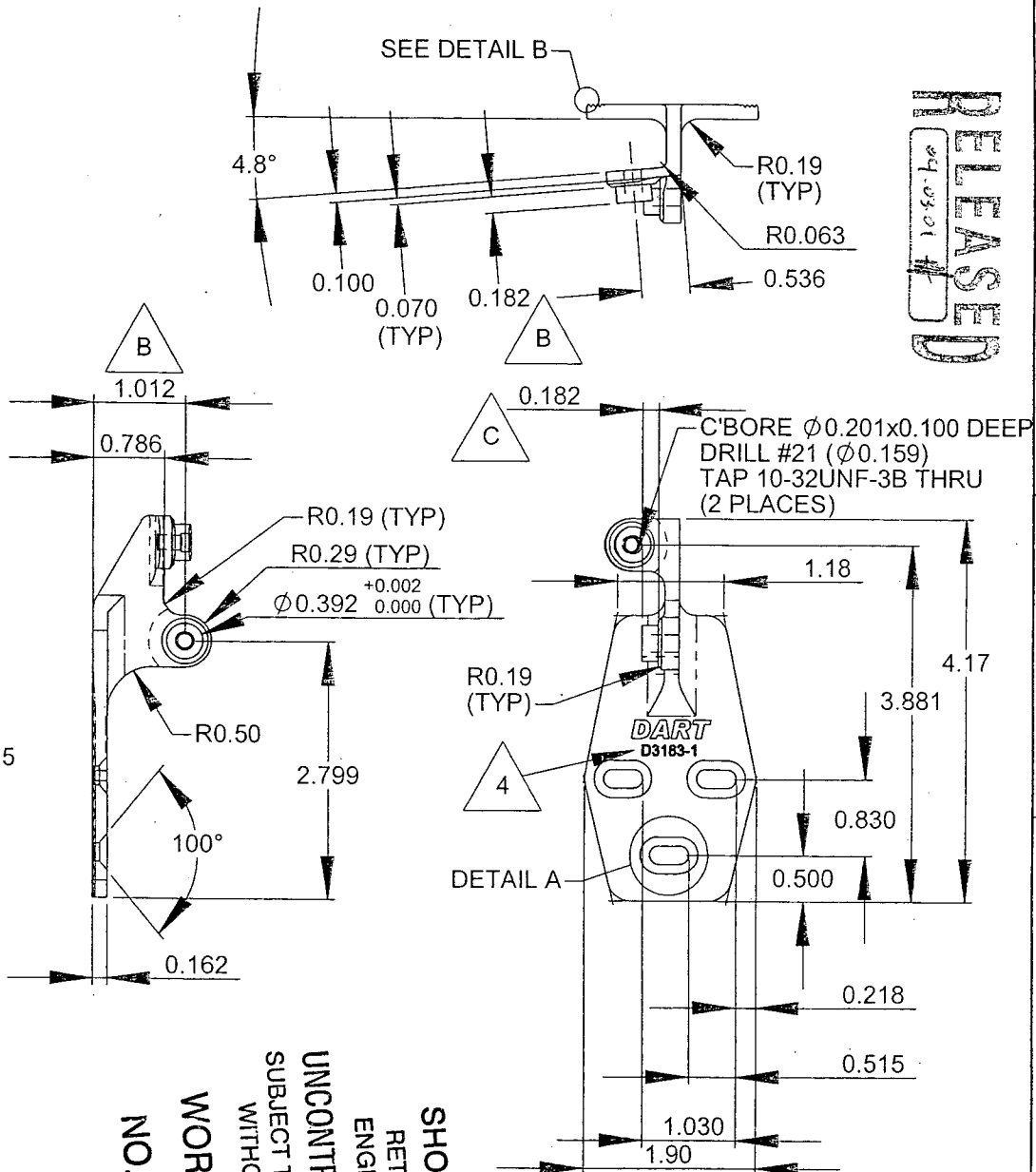
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DATE 04.02.17	DRAWING NO. D3183	REV. C
	TITLE BRACKET ASSEMBLY	SHEET 2 OF 4
		SCALE 1:2

RELEASED
04-03-01



D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

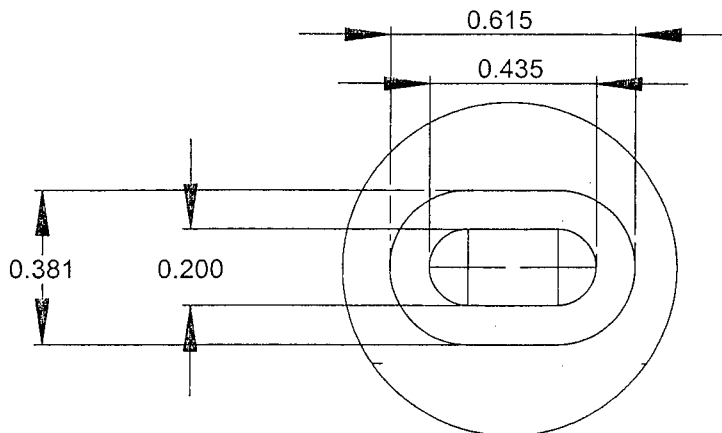
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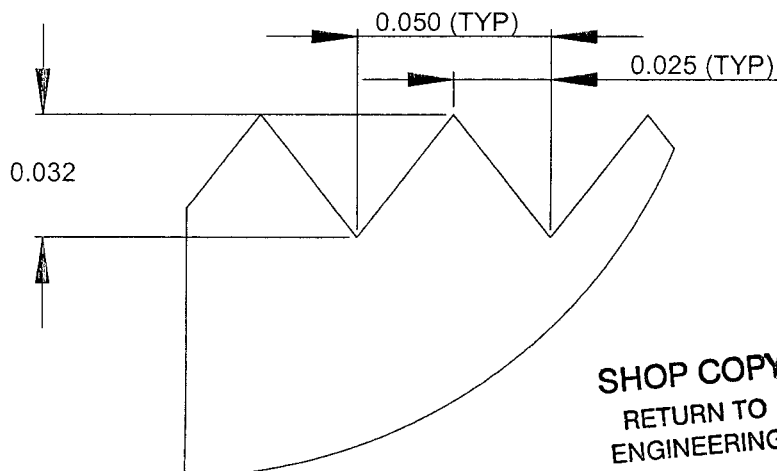


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1



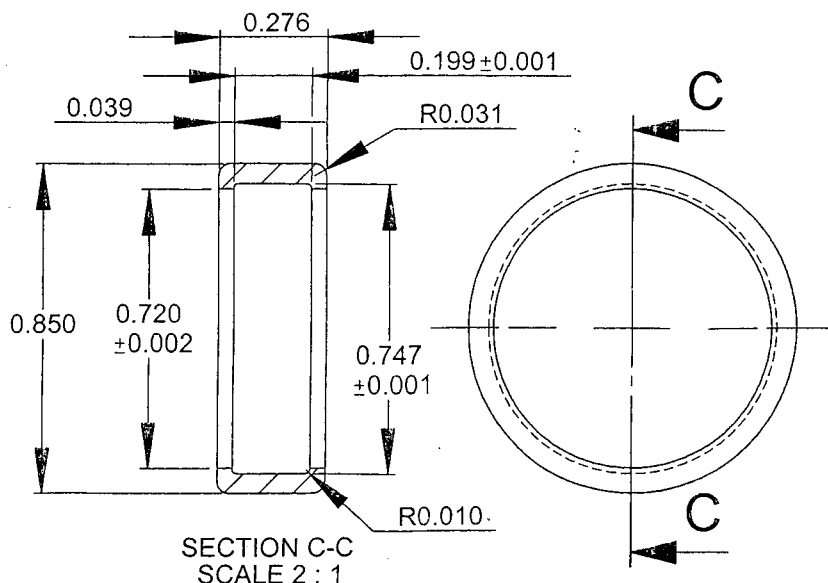
DETAIL A (2 : 1)

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04.03.01



DETAIL B (20 : 1)

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D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 23, 2004
09:51 am

Work Order No : 0021385
Project Name : D3183-041
Project For : WK440
Work Order Type : Main
Main WO Number :
House Part Number : D3183-041
Description : Bracket Assembly
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 08-23-04
Est Finish Date : 09-21-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00